Work Orde Thursday, Augus				*123	300*						Page 1
Revision ID:	D3536-25 Gasket Center			Accept	*N900	040	100	)*	Setup Sta	17	S1*
	8/07/14	<b>Start Qty:</b> 12.00 <b>Req'd Qty:</b> 12.00	*12* *12*		Cust Item 1 Customer:	D:				· "IVI	S2*
Approvals:	Process Plan	n: MLJ	Date: <u>  \                                  </u>	Tooling:SPC (Y/N):		ate:			Run Sta	^I/J	R1*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D3536	Rev .	A									
*100 *100* Waterjet FLOW CNC Waterje	et	FLOW WATER JET  Memo  1-Cut as pe  Deburr if no	r Dwg D3536 Dwg Rev:_ ecessary	0.00  0.00  A Prog Rev: A	_ 2-			I		[	C.14/08/19 DAS <b>46</b> D-89
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00						J	, /
*110* QC Quality Control		Мето		0.00				(13)		4	c <u>v/l</u> ay/19 As 1 <b>6</b> 89
120 *120*		QC8- Inspect parts - sec	ond check	0.00				(12)			DAS 38 11/2

0.00

Memo

Quality Control

DQA:		·	Date:										*DART
QA Closed:			Date:			WORK ORDER NON-	-CC	NFOI	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPĀCĒ
2, ( 0,0300.						DISPOSITION			AGAINST		PARTMENT	<u> </u>	
Work Orde	r: _					DISPOSITION	. 1		Adalitat	_	. A		
						Rework			Skid-tube Crosstube			Water Jet	Engineering
Part N	lo					Scrap			Machining Small Fab	$\vdash$	1	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming Finishing		Rec/Stor	re/Packaging	Other
NCR N	lo					Suspected Unapproved	J		Large Fab Composite	<u> </u>	j	Supplier	J
Root					Desci	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data	_												
Equip/Tooling													
Handling/Pre	_												
Material	_						ĺ		•				
Operator	_												
Offset/Setup	_												
Process	-												
Supplier	<u> </u>			1									
Training	$\dashv$						1						
Transport	<u> </u>				ľ								
Unapproved	L_		l	l	<u> </u>		FAI	ULT CA	TEGORY		L		<u> </u>
Landi	ng Ge	ar				General							
		ending				Bend		  Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		•	ot Conce	ntric		BOM/Route	$\vdash$	Grain			Over/Under	tolerance	Set-up
į	—	racks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí 🗍	Temperature/Cure
		rimp/Kir	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	issing	Weld
	-	uffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	$\Box$	rushing				Countersink		Misalig	gned/off center		Positioned V	Vrong	_
		leat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
		nspectio	n Strip in	Tube		Drawing		Misrea	d				
		/larks/Ch	atter			Drill Holes		Off-set					
	ו	urning S	equence	<b>:</b>		Finish		4	Calibration				
		Vave/Tw	ist in Tu	be		Fit/Function	<u>L</u> .	Out of	Sequence				

Work Order ID 123300 \*123300\* Page 2 Thursday, August 07, 2014 11:12:20 AM **Item ID:** D3536-25 Accept \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Gasket Center \*12\* **Start Date:** 8/07/14 **Start Qty: 12.00 Cust Item ID:** Required Date: 8/07/14 Reg'd Oty: 12.00 \*12\* **Customer:** Reference: Run Start Approvals: **Process Plan:** Date: Tooling: Date: Stop Date: **SPC (Y/N):** Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject **Work Center ID** Description **Run Hours** Code **Qty** Oty Number Stamp 130 Identify as per dwg & Stock Location: FPO 0.00 AUG 2 0 2014 \*130\* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

\*140\*

Quality Control

QC

ML 5 14-08-21

DQA:		Date:											DART
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT					AEROSPACE
QA Closed:		Date:		-					W	ork Order up	date only		
Work Order:					DISPOSITION		i	AG	GAINST DE	PARTMENT	PROCESS		
Work Order.					Rework			Skid-tube Cro	sstube		Water Jet		Engineering
Part No					Scrap			)	nall Fab	Pro	d. Eng. Coor.	П	Quality
		,			Use-as-is			· —	nishing		e/Packaging		Other
NCR No		<del></del> .	••		Suspected Unapproved			Large Fab Com	nposite		Supplier		
Root	]	1		Desc	ription of work order update		nitial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	1	Date	Verification	n	QC Inspector
Design			,					·					
Doc/Data	7												
Equip/Tooling	1												
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier												ĺ	
Training	_												
Transport		ł											
Unapproved					Mi-	<u> </u>		<u> </u>					· · · · · · · · · · · · · · · · · · ·
						FA	ULT CA	TEGORY	<del></del>				
Landing					General		1	_	r—	1			- /-
l	Bending	٠		_	Bend	<u> </u>	1	Program	<u> </u>	Outside Dim		-	Pressure/Forced
-	-	lot Concei	ntric	<u> </u>	BOM/Route		Grain		-	Over/Under		_	Set-up
-	Cracks		<b>6</b>	_	Broken/Damage/Defect	_	Hardwa			Part Incorred		-	Temperature/Cure
<u> </u>	_	ink/Ripple	e/Wave		Burrs	L	4 `	ion Incomplete/Unqualifi		Part Lost/Mi	ssing	Н	Weld
<u> </u>	Cuffs			<u> </u>	Contamination	$\vdash$	4	tions Incomplete/Unclear	r	Part Moved	M	Ш	Wrong Stock Pulled
<b> </b>	Crushing			<u> </u>	Countersink	-	-	gned/off center	<u> </u>	Positioned V	=	$\Box$	Other
-	Heat Tre		<b>T.</b> l	-	Cut Too Short	-	Mislab		L	Power Loss/	ourge	Ш	Other
-	<b>⊣</b> '	on Strip in	rupe	 	Drawing Drill Holos	$\vdash$	Misrea						
-	Marks/C			-	Drill Holes	$\vdash$	Off-set	Calibration					
-		Sequence			Finish Fit/Function	-	4						
1	wave/IV	wist in Tul	Je		Trit/ Fulliction	1	logr of	Sequence					

**Picklist Print** 

Thursday, August 07, 2014 11:12:20 AM

Work Order ID: 123300

\*123300\*

**Parent Item:** 

D3536-25

\*D3536-25\*

Parent Item Name: Gasket Center

**Start Date:** 8/07/14

Required Date: 8/07/14

**Start Qty:** 12.00

Required Qty: 12.00

**Comments:** 

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	377.9901	0.5956	8	DAS		<u> </u>
*MNF060 NEOPRENE SHEET 0.063						<u> </u>			**	·	<b>46</b> 9-89	TV.	14/09/19

<b>Location</b>	Loc Oty	Loc Code	
MAT052	377.9901		
M126546	2.3		
M128266	12.29		16.4
M128339	363.4001		

Page 1

DQA:			Date:			,			_		•		*DART
QA Closed:			Date:			WORK ORDER NON	l-CC	ONFO	RMANCE / UP		ork Order up	odate only	AEROSPACE
Work Orde	r.					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
WOIK Order	-					Rework	٦		Skid-tube	Crosstube	7	Water Jet	Engineering
Part No	ο.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-	- 111				Use-as-is	1	Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o					Suspected Unapproved	]		Large Fab	Composite		Supplier	
Root	T	•			Desci	ription of work order update		nitial	Acti	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	n QC Inspector
Design												·	
Doc/Data	╝												
Equip/Tooling	_												
Handling/Pre	_												
Material	Ц												
Operator													
Offset/Setup													
Process	_		]				ł						
Supplier							1						
Training													
Transport													
Unapproved				<u> </u>							<u> </u>	,	
						<u> </u>	FA	ULT CA	TEGORY				
Landin						General		1			٦.		
	$\dashv$	Bending			$\perp$	Bend		- '	Program	<u></u>	Outside Dim		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		<u> </u>	Over/Under		Set-up
1		Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>	Part Incorre		Temperature/Cure
<u> </u>		Crimp/Kir	nk/Ripple	/Wave		Burrs		4 '	ion Incomplete/Un	· -	Part Lost/M	issing	Weld
]	-	Cuffs				Contamination	$\perp$	-	tions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled
<u> </u>	_	Crushing				Countersink	L	4	gned/off center		Positioned V		
3		Heat Trea				Cut Too Short		Mislab			Power Loss/	Surge	Other
		Inspectio	•	Tube		Drawing	_	Misrea					
		Marks/Ch				Drill Holes		Off-set					
		Turning S				Finish	<u></u>	-	Calibration				
		Wave/Tw	ist in Tub	oe -		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	123300
Description: Gasket	Part Number:	D3536-25
Description: dasket	Part Number:	D3530-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80	1		1	JKM - 06
16.35	+/-0.030	16.35	1,	i	T	16 0
10.90	+/-0.030	10.90	7,		イ	10 60
5.45	+/-0.030	5.45			T	~~ ~~
6.00	+/-0.030	6.40	/,	1	1	ir ii
6.75	+/-0.030	6.75	1,	İ	T	( L
12.75	+/-0.030	12.75	1,	1	+	11 11
1.89	+/-0.030	1.89	1,		7	Jlen-01
0.30	+/-0.030	. 30	//		7	u v
0.30	+/-0.030	- 30	1		7	X L XX
Ø0.19	+0.005/-0.001	× C. 19			J	ι, ιι
	DAS		nae			

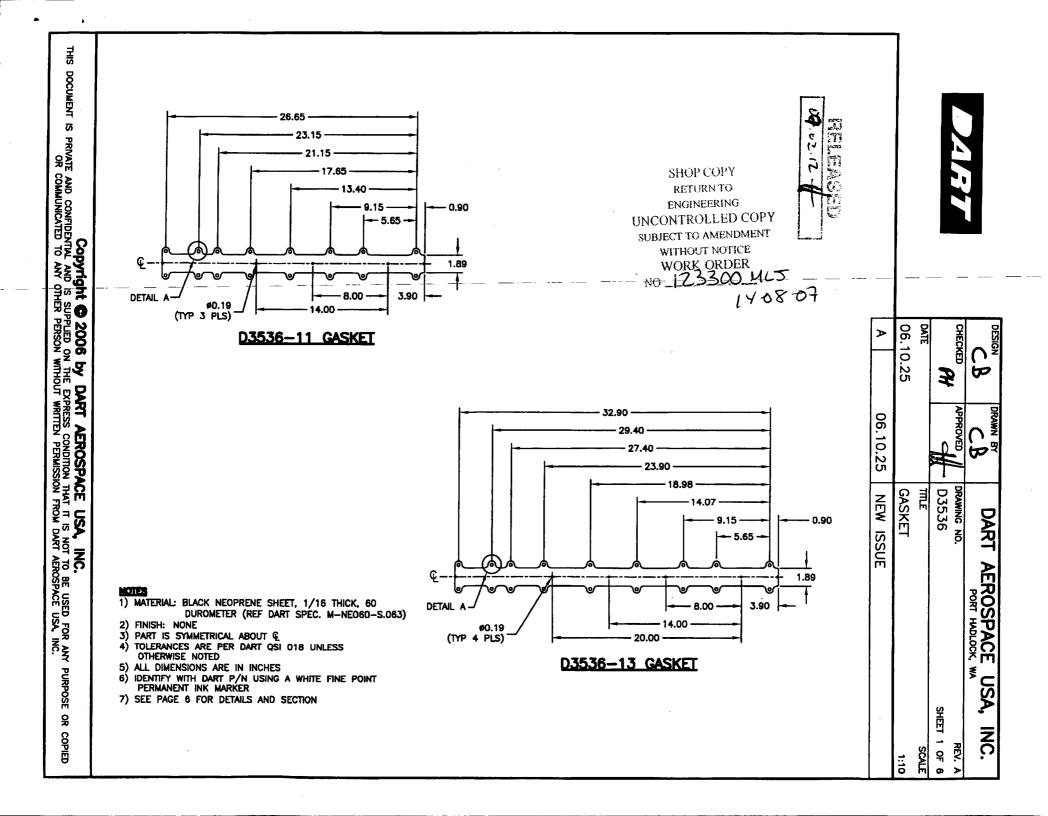
Measured by: Date: 14/08/20

Measured by: Date: 14/08/20

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
_ A	07.06.13	New Issue	 KJ/JLM	B
			, ()	



- 52.85 · 07.02.12 - 48.20 -44.70 - 39.31 -33.92 28.53 -- 23.14 -17.75 14.25 -DETAIL A 1.89 CHECKED DATE 06.10.25 - 16.00 ≠0.19 (TYP 6 PLS) - 24.00 - 32.00 田 3 39.00 48.00 D3536-23 GASKET APPROVED D3536 GASKET DRAWING NO. DART - 21.80 1.45 16.35 DETAIL A AEROSPACE PORT HADLOCK. 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063) R0.06 (TYP) 3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 1.89 RO.25 -- 6.00 (TYP) 5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER **#**0.19 USA, 7) SEE PAGE 6 FOR DETAILS AND SECTION (TYP 3 PLS) D3536-25 GASKET SHEET

NC.

u REV. A

SCALE 우 6

1:10

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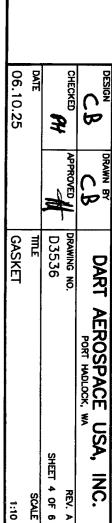
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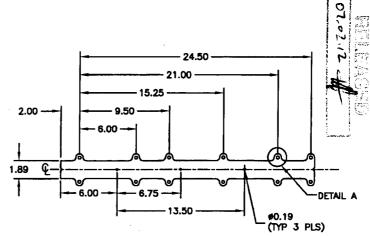
- 6.00

2) FINISH: NONE

2.00 -

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D3536-33 GASKET

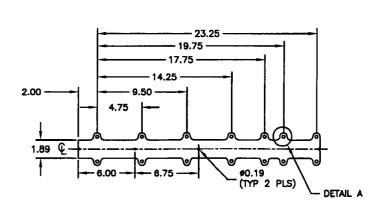
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		19.00			
		14.25			
2.00		9.50 ——			
ı	6.00	·-			
1.89 G		\_\_		<u>-(Q)</u>	9
1.89 4	6.00	6.75		Jan J	DETAIL A
		13.50	) <del></del>	ال کا	10.19 TYP 3 PLS)
	C	3536-31	GASKE	I	

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE

- 2) FINISH: NONE

  3) PART IS SYMMETRICAL ABOUT €
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

  5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-35 GASKET

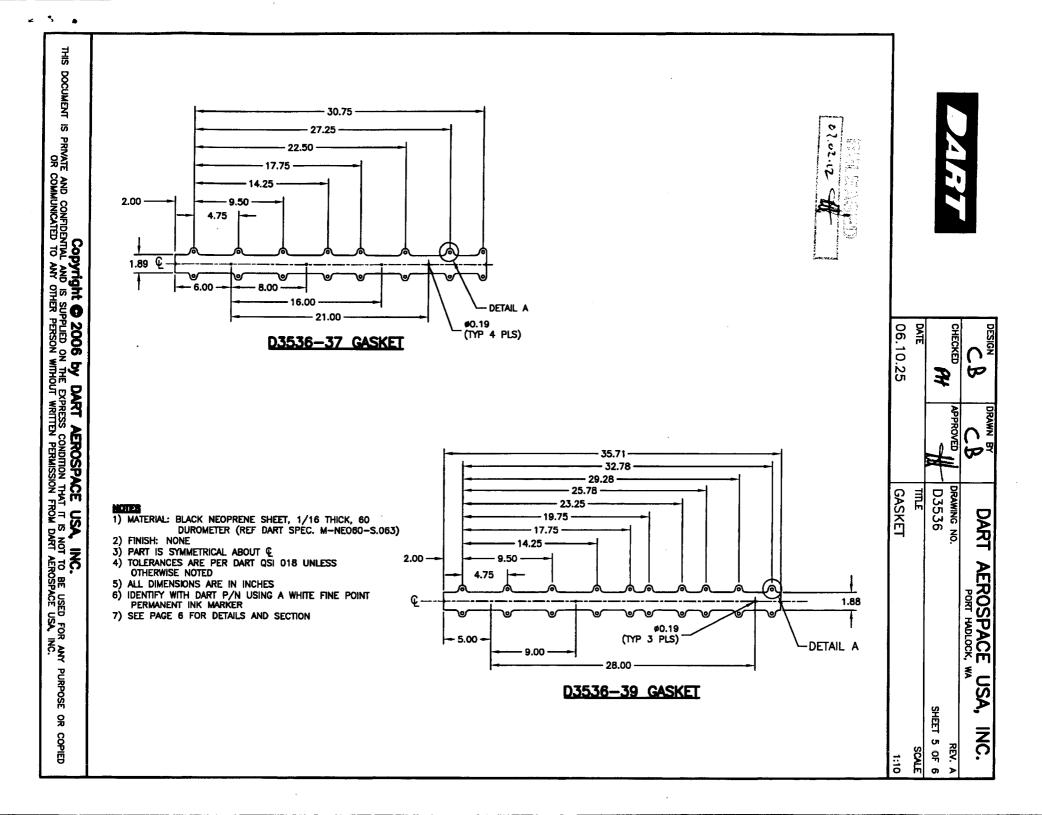
PURPOSE

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DOCUMENT



07:22.12

15.00 1.88 3.90 (TYP 2 PLS)

D3536-41 GASKET

- 27.98 - 25.08

- 18.50 -

2.00 -

4.00

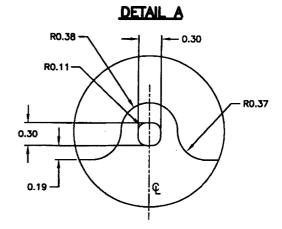
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DETAIL A

- MOTES

  1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
  DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
  3) PART IS SYMMETRICAL ABOUT €
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



 CB	CB	DART AEROSPACE USA, INC.
CHECKED	APPROVED ///	DRAWING NO. REV. A
m	*	D3536 SHEET 6 OF 6
DATE		TITLE
06.10.25		GASKET 1:10